

Work Order ID 137386

137386

Page 1

Friday, November 27, 2015 10:38:15 AM

Item ID: D206-559-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206A/B Bearpaws
 Start Date: 9/25/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/28/2015 Req'd Qty: 1.00 ***1*** Customer: CEDWA01
 Reference: RMA RA112151

Approvals: Process Plan: WME Date: 15-11-27 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9527	rev A								
IIN-D206-559	rev L								

100 0.00 ***100*** 1 **DAS 38 9-89**
 QC Memo 0.00
 Quality Control INSPECT RA112151

D206-559-011 X 1 B115079

CUSTOMER ORDERED WRONG KIT
 (WAS ASSEMBLED BY CUSTOMER)

DISASSEMBLE AND REUTRN TO STOCK UNDER ORIGINAL BATCH
 NUMBER:
 D2435 X 2 B117114
 D2438 X 4: 3 X B115202, 1 X B112483

SCRAP THE REST

NOV 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 137386***137386***

Page 2

Friday, November 27, 2015 10:38:15 AM

Item ID: D206-559-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206A/B Bearpaws

Start Date: 9/25/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/28/2015 Req'd Qty: 1.00

1

Customer: CEDWA01

Reference: RMA RA112151

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

QC21- Final Inspection - Work Order Release

0.00

110

QC

Memo

0.00

Quality Control

MWS 

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

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								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, November 27, 2015 10:38:14 AM

Page 1

Work Order ID: 137386

137386

Parent Item: D206-559-011

D206-559-011

Parent Item Name: 206A/B Bearpaws

Start Date: 9/25/2015

Required Date: 9/28/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:C04.02.17Blank size changedKJ/JLM
IPP Rev:D 07-01-02 Was K10007 JLM
IPP Rev:E 08-05-05 up a chg DD verified by:EC
IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified
By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-559-011		Manufactured	No				Each	9.0000		1			

D206-559-011

206A/B Bearpaws

Location	Loc Qty	Loc Code
FG	1	
81049	1	
FG014	8	
124335	3	
126696	5	

1 X 115079 MF 15-11-27

D2435

Manufactured No

Each 4.0000

-2

D2435

Bearpaw

Location	Loc Qty	Loc Code
ST446A	4	
117114	2	
137487	2	

MF 15-11-27

D2438

Manufactured No

Each 46.0000

-4

D2438

Clamp

Location	Loc Qty	Loc Code
ST542	46	
112483	1	
115202	3	
131052	42	

MF 15-11-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

RA112151

Received: September 16, 2015
Inspected: September 22, 2015

CUSTOMER: Bell Helicopters
CUSTOMER CONTACT: Michelle Perkins
SHIPPED FROM: Tennessee USA

Instructions for RA112151 D206-559-011 B115079 CHG 007

* 137386

- Customer order wrong part
- D206-559-011 B115079 was assemble by customer
- Disassemble kit and return in stock, scrap all hardware
- List of parts to return in stock
 - D2438 B115202 3x, B112483 1x
 - D2435 B117114 2x
- List of parts to scrap
 - D2274 8x (no batch number)
 - D2529 B115153 8x
 - AN4-17A B127817 8x
 - AN4-20A B127290 8x
 - NAS1149D0463J B127904 16x
 - MS210442L4 B128798 8x
 - D2182B050 4x (no batch number)
 - QS200M44S (not return)

Time Estimate: 2 hours

Departments Required: quality, small fab, stores

Pictures Attached: N/A

QTY INSPECTED: 2x D206-559-011 B115079 CHG 007

**THIS INSTRUCTION SHEET MUST BE
ATTACHED TO THE RESTOCKING
WORK ORDER AT ALL TIMES!!!!**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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LOT TRACKING !!

Parent Item ID /	Reason	Lot Qty	Lot Nbr	Lot Trans Date	Avg Cost Amt
AN4-17A	115079	-40	M127817	7/2/2014 10:18:03 AM	\$.28
AN4-20A	115079	-40	m127290	7/2/2014 10:18:03 AM	\$.31
D2182B	115079	-9	108914	7/2/2014 10:18:03 AM	\$1.21
D2274	115079	-40	115803	7/2/2014 10:03:58 AM	\$3.12
D2438	115079	-10	117114	7/2/2014 10:03:58 AM	\$180.16
D2438	115079	-5	112483	7/2/2014 10:03:58 AM	\$5.99
D2438	115079	-9	115202	7/2/2014 10:03:58 AM	\$5.99
D2438	115079	-6	32016	7/2/2014 10:03:58 AM	\$5.99
D2529	115079	-40	115153	7/2/2014 10:03:57 AM	\$.02
MS21042L4	115079	-40	m128798	7/2/2014 10:03:57 AM	\$.18
NAS1149D0463J	115079	-80	M127904	7/2/2014 10:03:57 AM	\$.03
QS200-44S	115079	-4	m126254	7/2/2014 10:18:03 AM	\$2.46
QS200-M44S	115079	-5	125957	7/7/2014 3:32:35 PM	\$1.81
QS200-M44S	115079	-1	119436	7/7/2014 3:32:35 PM	\$1.81

DQA: _____ Date: _____



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